



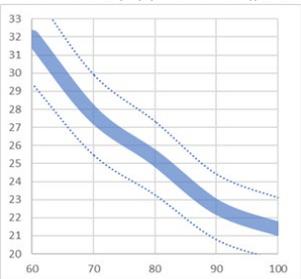
**SHERWIN
WILLIAMS.**

SHER-WOOD® Hi-Bild™ Precat Lacquer

GlossT77C55
Dull Rubbed Effect... T77F58

Bright Rubbed Effect.....T77F56
Flat.....T77F59

Medium Rubbed Effect.....T77F57
Custom Blend.....T77HX Series
Catalyst.....V66V3

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS																														
<p>SHER-WOOD® Hi-Bild™ Precat Lacquer is a fast drying, high performance, clear, conversion lacquer for the general wood finishing market. After catalyzation, it provides a 4 month pot life.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • 20% higher volume solids than traditional precat lacquers. • Meets KCMA specifications as a self-sealing system or over catalyzed Sher-Wood Vinyl Sealers, T67F3, T67F5 or T67F6 • Fast dry to sanding and packing. • Contains UV absorber to significantly reduce the discoloration of natural wood from exposure to sunlight. • Good resistance to household chemicals. • Good flexibility - passes 20 KCMA cold check cycles. • Versatile application – may be applied by conventional, airless, air-assisted airless spray. • Pale water white color. • Ideal for kitchen cabinets, vanities, chairs, office furniture, household furniture <p>Air Quality Data:</p> <ul style="list-style-type: none"> • Non-photochemically reactive • Volatile Organic Compounds (VOC) theoretical as packaged, maximum less exempt solvents: 5.18 lb/gal, 620 g/L. Catalyzed and reduced (R7K305 at 10%) 5.31 lb/gal 630 g/L • Volatile Hazardous Air Pollutants (VHAPS) as packaged maximum: Not reportable VHAPS <p>VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility, or at www.paintdocs.com.</p>	<p>Gloss:</p> <table border="0"> <tr><td>Gloss</td><td>85+ units</td></tr> <tr><td>BRE</td><td>55-59 units</td></tr> <tr><td>MRE</td><td>34-38 units</td></tr> <tr><td>DRE</td><td>17-21 units</td></tr> <tr><td>Flat</td><td>4-8 units</td></tr> </table> <p>Volume Solids: 25 ± 2% Weight Solids: 33 ± 2%</p> <p>Viscosity: T77F59: 20-25 seconds #2 Zahn Cup All others 25-30 seconds #2 Zahn cup</p>  <p><i>The above chart is for information only and should not be used as product specifications</i></p> <p>Recommended film thickness:</p> <table border="0"> <tr><td>Mils Wet</td><td>3.0 - 5.0</td></tr> <tr><td>Mils Dry</td><td>0.75 - 1.25</td></tr> </table> <p>Maximum dry film thickness of the entire system should not exceed 4.0 mils</p> <p>Spreading Rate (no application loss) 395-580 sq ft/gal @ 0.75-1.25 mils DFT</p> <p>Drying (77°F, 50% RH):</p> <table border="0"> <tr><td>To Touch:</td><td>10-15 minutes</td></tr> <tr><td>To Handle:</td><td>15-20 minutes</td></tr> <tr><td>To Sand:</td><td>30-45 minutes</td></tr> <tr><td>To Recoat:</td><td>30-45 minutes</td></tr> <tr><td>To Pack:</td><td>8 hour minimum</td></tr> <tr><td>Force Dry:</td><td>5-10 minutes at 110- 140°F, then air dry 1 hour minimum to pack</td></tr> </table> <p>Flash Point: 4°F Pensky-Martens Closed Cup</p> <p>Mixing Ratio:</p> <table border="0"> <tr><td>1 gallon</td><td>Lacquer</td></tr> <tr><td>3.0 ounces</td><td>Catalyst, V66V3</td></tr> </table> <p>Pot Life: 4 months</p> <p>Package Life: 2 years, unopened</p>	Gloss	85+ units	BRE	55-59 units	MRE	34-38 units	DRE	17-21 units	Flat	4-8 units	Mils Wet	3.0 - 5.0	Mils Dry	0.75 - 1.25	To Touch:	10-15 minutes	To Handle:	15-20 minutes	To Sand:	30-45 minutes	To Recoat:	30-45 minutes	To Pack:	8 hour minimum	Force Dry:	5-10 minutes at 110- 140°F, then air dry 1 hour minimum to pack	1 gallon	Lacquer	3.0 ounces	Catalyst, V66V3	<p>Surface preparation:</p> <p>Wood - New Work (interior only): Must be clean, dry, and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties. Moisture content of wood should be 6 to 8%.</p> <p>Previously finished wood (interior only): Strip old finishes completely and remove all contaminants from the surface. Make sure surface is dry. Finish as new work.</p> <p>Wood Finishing System: THIS PRODUCT MUST BE CATALYZED.</p> <ol style="list-style-type: none"> 1. Color Wood - Stain or tone as desired and dry thoroughly. 2. Seal - Apply Sher-Wood Hi-Bild Precat Lacquer as a sealer or seal with catalyzed Sher-Wood Vinyl Sealers, T67F3, T67F5 or T67F6. (Consult corresponding data page for details). Spray a full wet coat. Air Dry 30 – 45 minutes. 3. Sand - Sand with 240 grit or equivalent. Remove sanding dust. 4. Topcoat - Spray a full wet coat of Sher-Wood Hi-Bild Precat Lacquer at 3.0-5.0 mils wet. 5. For more depth or build, apply an additional coat. Do not exceed 4.0 mils DFT for the total system. <p>Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.</p>
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APPLICATION

Typical Setups

THIS PRODUCT MUST BE CATALYZED
DETERMINE IF IT HAS BEEN CATALYZED. If not catalyzed, add 2.3% (3.0 oz/gal) Sher Wood Hi-Bild Precat Catalyst, V66V3. Pot-life after catalyzation is 4 months. Record the catalyzation date on the container.

Reduction: Product is normally applied without reduction. If reduction is needed to optimize application, use 5-10% HAPS Compliant Lacquer Thinner R7K320, HAPS Free Reducer R7K305, or Acetone R6K9. Lacquer Thinner K120 or K22 may also be used, but are not HAPS compliant.

Retard: To retard, use either MAK R6K30, at 5-10%, EEP R6K35 at 2-5% or 2-Butoxyethanol R6K25, at 1-2% maximum.

Conventional Spray:

Air Pressure 35 - 60 psi
Fluid Pressure 6 - 10 psi
Cap/Tip 797

Airless Spray:

Pressure 1500 - 1800 psi
Tip011 - .013"

Air Assisted Airless:

Air Pressure 20 - 30 psi
Fluid Pressure 500 - 900 psi
Cap/Tip011 - .013

HVLP:

Gun Binks Mach 1
Atomizing Air Pressure at the cap 9 psi
Fluid Pressure 12 psi
Cap/Tip 97AP Blue Max/94

Cleanup:

Clean tools/equipment immediately after use with HAPS complying Lacquer Thinner, R7K320. Lacquer Thinner K120 or K22 may also be used, but are not HAPS compliant.

Follow manufacturer's safety recommendations when using any solvent.

Performance Tests:

Household Chemicals Test

Using ANSI-KCMA A161.1-2012 test procedures, panels were cured by air drying and allowed to age 10 days at ambient conditions before testing. Tests were conducted on self-sealed (2 coat) finished panels at 2.0 mils total DFT. Materials were washed off with clear water after 24 hours and allowed to recover for 10 days then the finish was examined and the following results noted:

Vinegar no effect
Lemon Juice no effect
Orange Juice no effect
Grape Juice no effect
Tomato Catsup no effect
Coffee @ 115° F no effect
Olive Oil no effect
100 Proof Alcohol no effect
Water & Detergent no effect
Mustard (1 hour) no effect
Cold Checks 20 cycles Pass
Edge Soak Pass

ADDITIONAL INFORMATION

- This product **must** be catalyzed with Sher-Wood Hi-Bild Precat Catalyst, V66V3, before use at a level of 2.3% (3.0 oz/gal). Complete cross linking and film properties will not be attained without catalyzation. Product will typically be catalyzed before delivery to the customer.
- This product should be used within 4 months after being catalyzed to obtain optimum properties. The catalyst causes a chemical reaction in the package and dissipates after 4 months, performance properties are downgraded. **Adding additional catalyst does not restore film properties.**
- Store at room temperature (under 80° F) after catalyzation. Higher temperatures will reduce the storage life.
- Self-seal or apply over catalyzed Sher-Wood Vinyl Sealers, T67F3, T67F5 or T67F6 to meet KCMA requirements.
- To achieve optimal results, a minimum of 2 mils DFT is required.
- Total film thickness of systems must not exceed 4 mils DFT because heavier films may show cracking and checking tendencies.
- For interior use only.
- Sher-Wood Hi-Bild Precat Catalyst, V66V3 is an acid. To prevent acid corrosion and pitting, all equipment should be made of stainless steel. Containers should be stainless steel or plastic.
- Do not catalyze with other acid catalysts because of fast reactivity and pot life issues.
- Maximum cure and chemical resistance is attained after 10 days air drying.
- Natural wood will change color by itself and clear wood finishes will not keep this from occurring.
- To maintain HAPS compliance, only reduce with HAPS compliant reducers.
- Sher-Wood Hi-Bild Precat Lacquer will yellow over time. With wood tone stains, this yellowing actually makes a warmer, softer appearance. Where white stains, pickled finishes, or white basecoats are used, nitrocellulose lacquer should not be used because of the yellowing of the sealer and topcoat may be considered objectionable. For these applications, Sher-Wood Acrylic Conversion Coating is recommended.

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CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.paintdocs.com.

Please direct any questions or comments to your local Sherwin-Williams facility.

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